

Date: Wednesday, 1/18/2006 4:06:15 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 STEP (EXTENDED HEIGHT)
Job Number	: 25558		
Estimate Number	: 10182		
P.O. Number	: N/A	Part Number	: D205633013
This Issue	: 1/18/2006 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 2/15/2006
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>	Qty:	8 Um: Each
Comment	: Est Rev:F 02.07.11 Reformat; Removed D3010 RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	25558A	STEP WELDMENT
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Comment: Sub-Component STEP WELDMENT

2.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP205-633-013 CHG001

KS 02/02/27

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D2021101	Eyebolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2021-101 Eyebolt B23 483

5.0	D2022101	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2022-101 Spacer B23 396

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:06:16 PM
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Drawing Name: 205 STEP (EXTENDED HEIGHT)

Job Number: 25558

Part Number: D205633013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022103

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2022-103 Spacer B24271

7.0

D2562003

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2562-003 Strut B21599 ymcp B 23484

8.0

D2565201

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-201 Strut B23486

& stock

9.0

D2565203

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-203 Strut B25573

10.0

D2565205

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-205 Strut B23487

11.0

D2565207

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-207 Strut B23665

& stock

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Job Number: 25558

Part Number: D205633013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2565209

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-209 Strut B25574 ✓

13.0

D2565211

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2565-211 Strut B23488 ✓

14.0

AN45A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-5A Bolt M100089

15.0

AN46A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-6A Bolt M19278

16.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN4-7A Bolt M17697 2mc

M18369 14mc

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Job Number:



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17.0	AN414A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN4-14A Bolt M15072

18.0	AN56A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN5-6A Bolt M18576

19.0	AN514A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 AN5-14A Bolt M7408 ymc

M17566 ym

20.0	AN960JD416	Washer
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Comment: Qty.: 15.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

15 AN960JD416 Washer M17566 72mc

M1908548m

21.0	AN960JD516	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M18100

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D205633013

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut *M 15924 36 mcp M 17997 28mcp*

23.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5 Nut *M 19073*

24.0

D2563

Step Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2563 Step Weldment *B25558*

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-013

Location: *REV H*

27.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 060310

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Heli Access Step (205 Extended Height)		Part Number:	D205-633-013
Dwg:		Qty:	
Ref:		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty																																																																																												
1	DC	Issue Travellers for: D205-633-013 205 Step (Std Height) D2563 Step Weldment Assy																																																																																															
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6	PK	Identify and pack for shipping as per PPP D205-633-013																																																																																															
7	AC	Cost / part: _____																																																																																															
8	DC	Close work Order and Ensure Travellers Attached Inspect Level 21 Travellers: D205-633-013 D2563																																																																																															

Rev	Date	Change	Revised By	Approved
A	97.03.05	New Issue	JB	
B	00.03.27	Reformat	EC	
C	01.04.02	Added D3010 to pick list	EC	
D	01.04.09	Incorporated D2563 step	EC	
E	02.07.11	Reformat; removed D3010 from Step 3	RF	
F	05.06.08	Added hardware per DSI 9302-013	KJ/JLM	

SUPERCEDED BY

CORD 2005-11-03

Est 10182

RELEASED
2005-06-08